

Work Order ID 74111-1

Wednesday, September 21, 2011 3:10:49 PM

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Item ID: D3286-1

Revision ID:

Item Name: Doubler

Start Date: 9/21/2011 Start Qty: ~~80.00~~ 20

Required Date: 10/3/2011 Req'd Qty: 80.00

Reference:

Approvals: Process Plan: *[Signature]*

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

Draw Nbr

Revision Nbr

D3286

Rev A

100



Waterjet

FLOW CNC Waterjet

304 .125

FLOW WATER JET

Memo

1-Cut as per Dwg D3286

Dwg Rev: *A*

Prog Rev: *A*

2-Deburr if necessary

0.00

0.00

B11-9-21



110



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

B11-9-21

120



QC

Quality Control

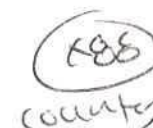
QC8- Inspect parts - second check

Memo

0.00

0.00

S. Miller



Work Order ID 74111

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Date:

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Brake NC

Brake NC

NC BRAKE

Memo

Form as per Dwg D3286

0.00

0.00

SB 11/09/22

20

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

SB 11/09/23

counters
20

150



Packaging

Packaging

Identify as per dwg & Stock Location: LG

Memo

STOCK IN SKIDTUBE CELL

0.00

0.00

"h23" 20

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Item ID: D3286-1

Revision ID:

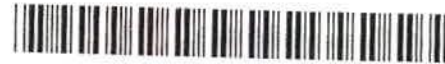
Item Name: Doubler

Start Date: 9/21/2011 Start Qty: 80.00

Required Date: 10/3/2011 Req'd Qty: 80.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/9/21
MF
11-09-23

Picklist Print

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Page 1

Work Order ID: 74111

Parent Item: D3286-1

Parent Item Name: Doubler





Start Date: 9/21/2011

Required Date: 10/3/2011

Start Qty: 80.00

Required Qty: 80.00

Comments: IPP A 04.07.14 New issue KJ/JLM
IPP Rev:B Now on Waterjet 06-06-16 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304SHGA 		Purchased	No			100	sf	23.0000	0.0749	6.307368	6.6		
304/316 0.125 Sheet													

HB 1-9-21

Location

MAT020

117494

Loc Qty

23

23

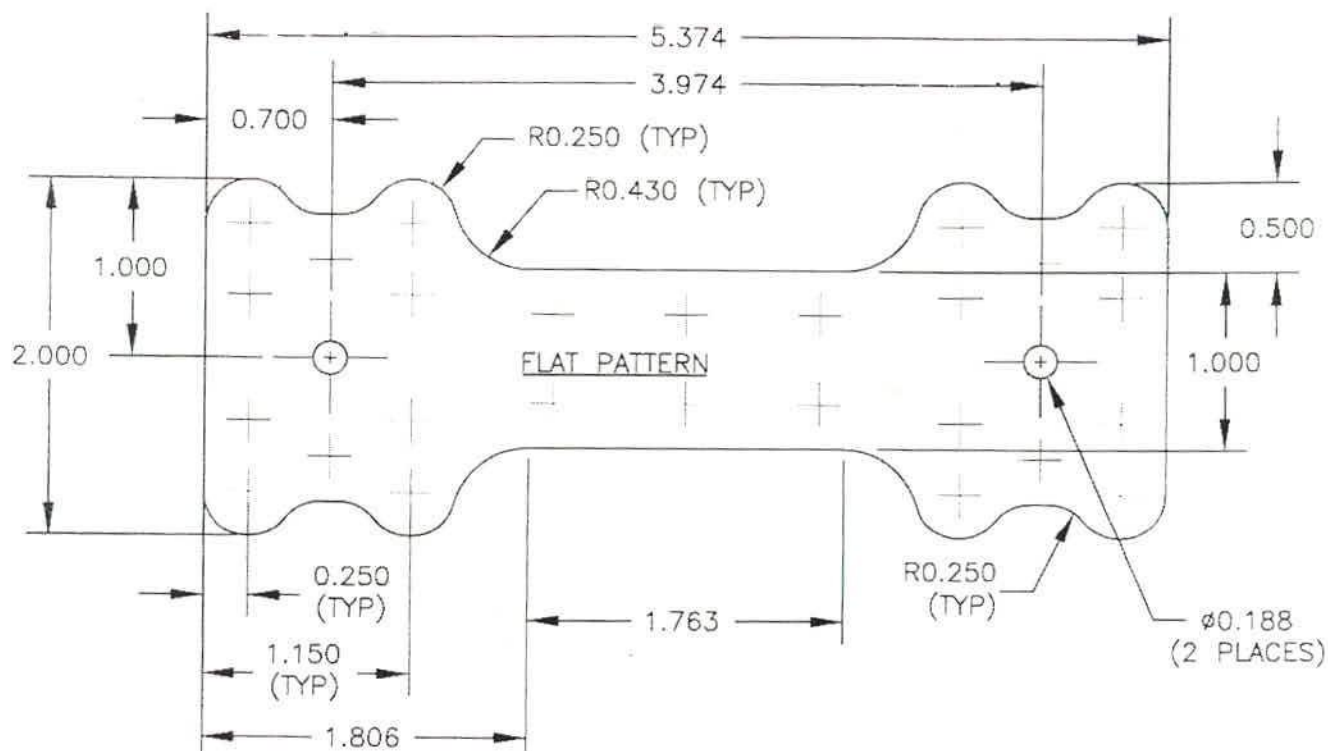
Loc Code

117494

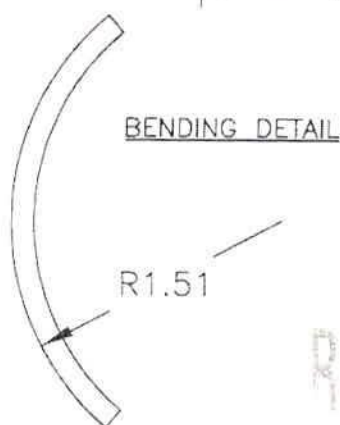
(88)



DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	
		PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	REV. A
		D3286	SHEET 1 OF 2
DATE		TITLE	SCALE
04.05.06		GROUND HANDLING PARTS	1:1
A	04.05.06	NEW ISSUE	



+ INDICATES LOCATION OF RIVET HOLES. SHOWN FOR REFERENCE ONLY, DO NOT DRILL.



D3286-1 DOUBLER

- 1) MATERIAL: AISI 304/316 SS SHEET 0.125" THICK
(REF DART SPEC. M304S11GA)
- 2) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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